

Work Order ID 52925

October 19, 2009 10:57:15 AM

Page 1

Item ID: D3957-042

Accept

Revision ID: A

Item Name: Hinge Assembly, Door RH Upper

Setup Start

Stop

Start Date: 10/19/09 Start Qty: 4.00

Required Date: 11/02/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *RL*

Date: *10-19-09*

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3957	A

100 Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

1-Install Helicoil in d3957-2

0.00

Small Fab

2-Install Rod end and Nut Loosely

120

0.00



QC

Memo

QC5- Inspect part completeness to step on W/O

0.00

Quality Control



=> m-h 09/11/30

(8X) /

=> m-h 09/11/30

(8X) /

=> 8 09/11/30

(66) /

Picklist Print

October 19, 2009 10:57:20 AM

Page 1

Work Order ID: 52925

Parent Item: D3957-042A-PRELIM

Parent Item Name: Hinge Assembly, Door RH Upper

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3518-3RevB		Manufactured	No			100	Each	18.0000	4.0000			
Stainless Steel Ball Joint Rod End												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

48211

Main Warehouse

ST109

51108

52270

15

5

10

D3957-2A-PRELIM

Manufactured

No

100

Each

0.0000

4.0000

Hinge, Door RH Upper

MS124818

Purchased

No

100

Each

50.0000

4.0000

Helicoil

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112503

50

50

M112503

2X m-l 09/11/26

4X m-l 09/11/30

2X m-l 09/11/26

1X m-l 09/11/30

4X m-l 09/11/26

4X m-l 09/11/30

Picklist Print

October 19, 2009 10:57:20 AM

Work Order ID: 52925



Parent Item: D3957-042A-PRELIM



Parent Item Name: Hinge Assembly, Door RH Upper

Start Date: 10/19/09

Required Date: 11/02/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-6		Purchased	No			100	Each	18.0000	4.0000			



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

109249

8

112492

10

M 113147

=7

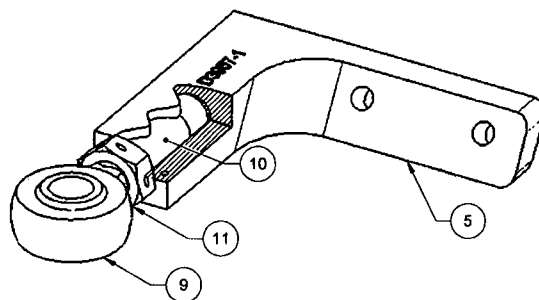
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m.h 09/11/30

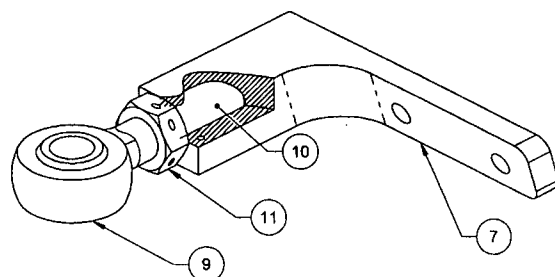
~~6X~~

2X

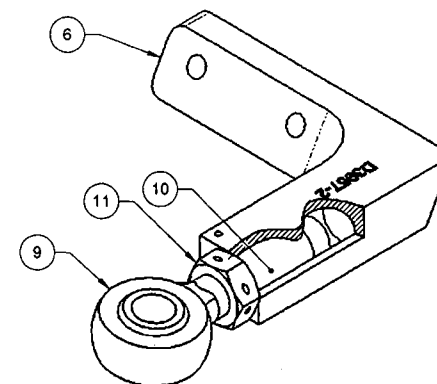
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



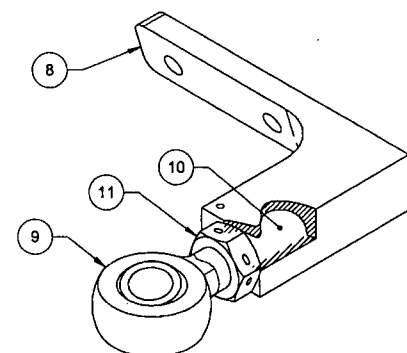
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

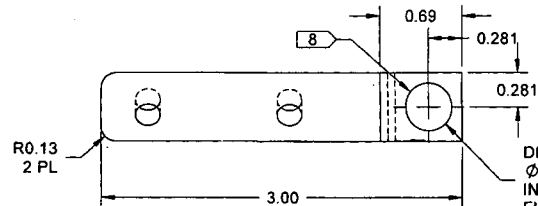
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RETURN TO
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SUBJECT TO A. NO. 100
WITHDRAWN
WORK ORDER
NO. 52925
PL 0910-12

RELEASED
2009-10-08
JWP

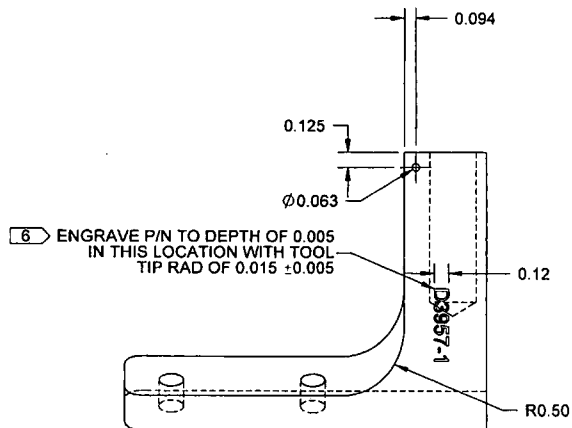
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REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3957	REV. A SHEET 1 OF 5
TITLE HINGE	SCALE NTS

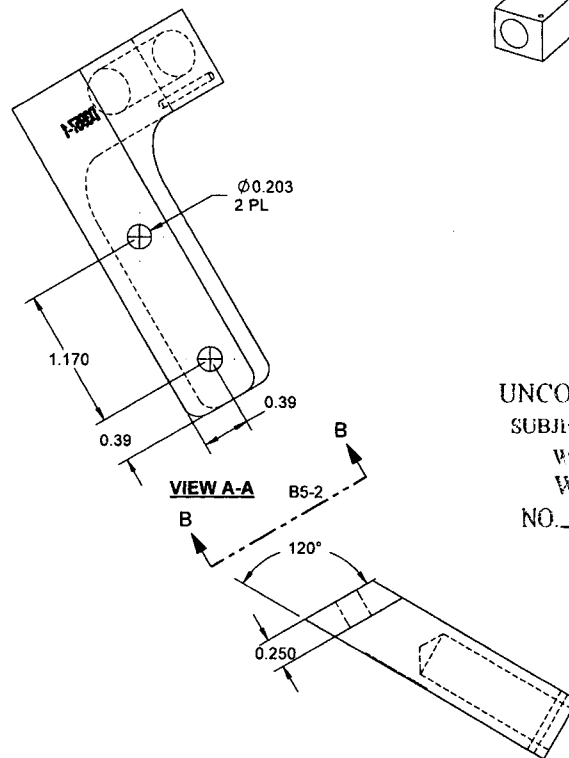
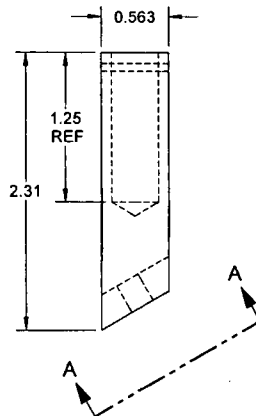
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 \pm 0.005



VIEW B-B

SHOP COPY
 REFERENCE
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 WITHOUT NOTICE
 NO. 52925

C3-2

RELEASE
 2009-10-08

D3957-1 HINGE, DOOR LH UPPER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 2 OF 5
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HINGE	NTS
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8

7

6

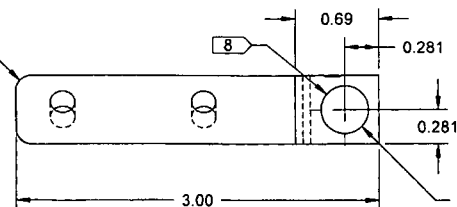
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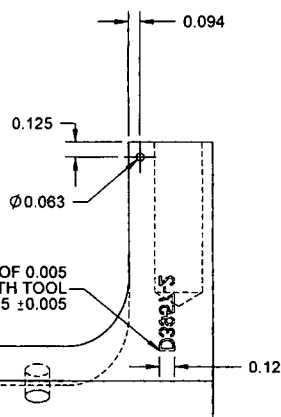
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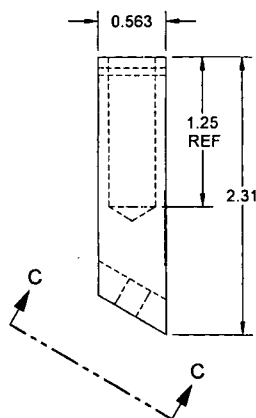
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R0.13
2 PL

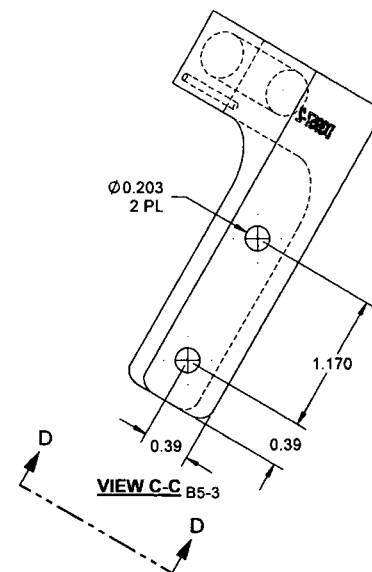
DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



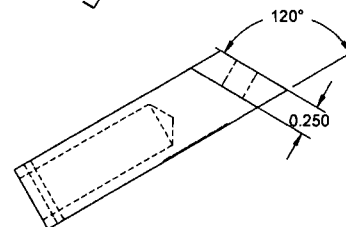
6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 \pm 0.005



D3957-2 HINGE, DOOR RH UPPER

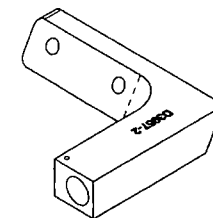


VIEW C-C B5-3



VIEW D-D

C3-3



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 RETURN TO
 ENGINEERING
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 WITH ORIGINAL
 WORKING
 NO. 62925

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
 2009-10-08

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3957	SHEET 3 OF 5
APPROVED	14	TITLE	SCALE
DE APPR.	14	HINGE	NTS
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8 7 6 5 4 3 2 1

R0.13
2 PL

8

0.69

0.281

0.281

3.00

DRILL AND TAP FOR 3/8-24 HELICAL INSERT
Ø0.391 X 1.25 DP
INSTALL HELICOIL MS124818
FLUSH WITH SURFACE

0.125

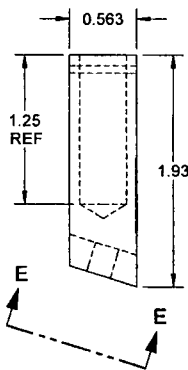
0.094

Ø0.063

6 ENGRAVE P/N TO DEPTH OF 0.005
IN THIS LOCATION WITH TOOL
TIP RAD OF 0.015 ±0.005

0.12

R0.50



Ø0.203
2 PL

1.170

F 0.33

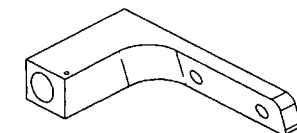
0.39

VIEW E-E B5-4 F

107°

0.250

VIEW F-F C3-4



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ENGINEER
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SUBJECT TO APPROVAL
WITHOUT
WORK
NO 52925

RELEASED
2009 -10- 08
MAD

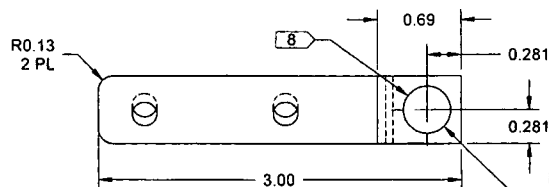
D3957-3 HINGE, DOOR LH LOWER

NOTES:

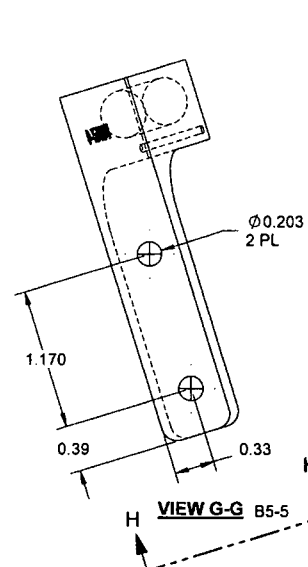
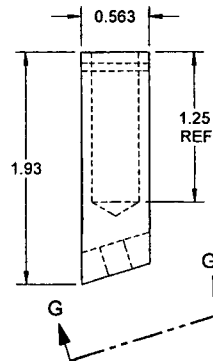
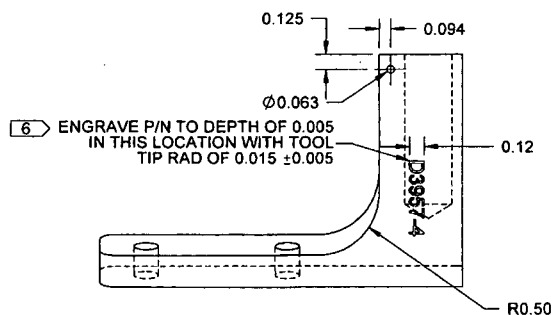
- 1) MATERIAL: 6061-T6 (6061-T651/T6511/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	45	DART AEROSPACE LTD	
DRAWN	45	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3957	SHEET 4 OF 5
APPROVED	42	TITLE	SCALE
DE APPR.	44	HINGE	NTS
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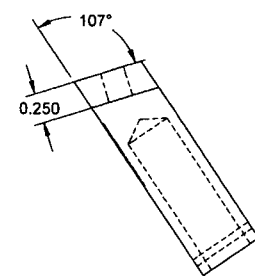
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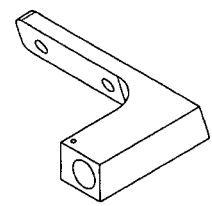
DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



VIEW G-G B5-5



VIEW H-H C3-5



SHOP COPY
 REFERENCE
 ENGINEER
 UNCONTROLLED
 SUBJECT TO ALL
 WITHOUT
 WORK ORDER
 NO. 82925

D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
 2009-10-08
 NWD

DESIGN	45	DART AEROSPACE LTD	
DRAWN	45	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	24	D3957	SHEET 5 OF 5
APPROVED	42	TITLE	SCALE
DE APPR.	42	HINGE	NTS
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8 7 6 5 4 3 2 1